

De rev 54988
Work Order ID 48386-1

June 26, 2009 12:39:33 PM



Page 1

Item ID: D3560-042

Accept



Setup Start



Revision ID: D

Stop



Item Name: Arm Weldment

Start Date: 15/07/2009 Start Qty: 8.00

Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

10-01-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3560

Rev D

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 16.750" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA694 Rev: _____ & Dwg D3560 Rev: _____ ! 2-C'sink
0.196" hole on manual mill as per dwg D3560; 13-Deburr per dwg D3560

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Work Order ID 48386

June 26, 2009 12:39:33 PM



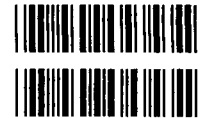
Page 2

Item ID: D3560-042
Revision ID: D
Item Name: Arm Weldment

Accept



Setup Start
Stop



Start Date: 15/07/2009 Start Qty: 8.00
Required Date: 03/08/2009 Req'd Qty: 8.00

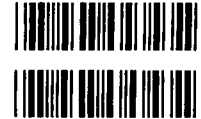


Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC
Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

140

Large Fab
Large Fab

Large Fab

0.00

Memo

0.00

1-Weld assembly as per dwg D3560 STEP: 1- clean material (buff bracket and bottom of arm with blue pad) 2- set up bracket and arm on jig 3- preheat bracket and arm with torch 4- clean before welding with brush 5- set up machine to 135 ampsi 6- weld across

10-01-05

150

QC
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10/01/11

x7

(See PTO OLD W/O)

Work Order ID 48386

June 26, 2009 12:39:33 PM

Page 3

Item ID: D3560-042

Accept

Revision ID: D

Item Name: Arm Weldment

Setup Start

Stop

Start Date: 15/07/2009 Start Qty: 8.00

Required Date: 03/08/2009 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.01.08

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-01-12 (7) 0

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7M 10-01-12 (X7) 0

Work Order ID 48386

June 26, 2009 12:39:33 PM



Page 4

Item ID: D3560-042

Accept



Setup Start



Revision ID: D

Stop



Item Name: Arm Weldment

Start Date: 15/07/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

I-Press bushing in D3560 arm per dwg D3562

ES 10/01/12 (7)

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

278 10/01/13

(+7)

082

210

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD
10-01-14

7

Work Order ID 48386

June 26, 2009 12:39:33 PM



Page 5

Item ID: D3560-042
Revision ID: D
Item Name: Arm Weldment

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 8.00



Required Date: 03/08/2009 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/14

MF
10-1-14

Picklist Print

June 26, 2009 12:39:32 PM

Page 1

Work Order ID: 48386

Parent Item: D3560-042RevD

Parent Item Name: Arm Weldment




Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2808RevB  Bushing		Manufactured	No			100	Each	0.0000	8.0000			
✓ M6061T6B0.500X05.00 0  6061-T6 Bar .500 x 5.00		Purchased	No			140	f	0.0000	11.7474			
✓ D3592-1RevB  Plate		Manufactured	No			190	Each	0.0000	8.0000			

Handwritten notes:
B46738 10-1-12 SP
M112154 = 7
B 48517 = 7
09.12.29
09.12.29

Date: Monday, 08/06/2009 9:24:25 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 48386	
Estimate Number : 12882	
P.O. Number :	Part Number : D3560042
This Issue : 08/06/2009 S.O. No. :	Drawing Number : D3560 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 47864	Material :
Written By :	Due Date : 15/06/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JUD 09-06-08</u>	
Comment :	
Est Rev:A New Issue 07.05.24 EC	
est rev B ECN 987 07.10.09 EC verified by: DD	
Est Rev:C ECN1048 07-12-18 DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	✓	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00
-----	---	--------------------	-------------------------



Comment: Qty.: 1.4648 f(s)/Unit Total: 11.7180 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M112154

ml 09/07/06

⑧

2.0	✓	BAND SAW	BAND SAW
-----	---	----------	----------



Comment: BAND SAW

Cut blanks 16.750" long

ml 09/07/06

⑧

3.0	✓	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: B & Dwg D3560 Rev: D

Pto

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

SL ml 09/07/09

4.0	✓	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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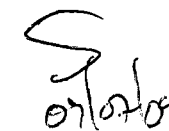
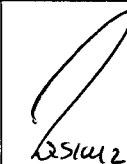
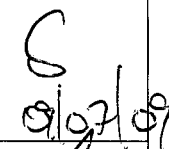
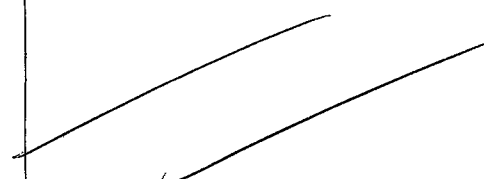
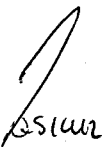

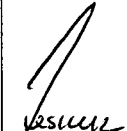
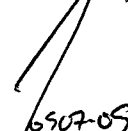


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL ml 09/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3560-042 PAR #: N/A Fault Category: MACHINE NCR: Yes No DQA: 1 Date: 10.01.18
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 10/02/11

NCR: <u>48386</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/07/09	3.0	clamping holes are drill .248 off in "X" at 165 because of computer bug P.C. machine malfunction		Scrap and destroy AND replace x1 BY <u>MU2154</u>	<u>mmf</u> 09/07/09			
				Part was correctly set-up. only 1 way to do it. 				

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 9:24:26 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 48386

Part Number: D3560042

Job Number:



Seq. #: ☒ Machine Or Operation:

Description :

5.0

☒ QC8

SECOND CHECK



Comment: SECOND CHECK

S086769 (X8)

6.0

☒ D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLATE 348517

09.12.29

09.12.05

7.0

☒ LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheate with torch (65 deg C)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

8.0

☒ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S10010 x (F)

9.0

☒ QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 10.01.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3560-042 ^{CAR 16-001} PAR #: ~~NA~~ Fault Category: Large Fab NCR: Yes No DQA: ~~NA~~ Date: 10.01.19
 Resolution: Re-weld Disposition: Re-weld QA: N/C Closed: ~~NA~~ Date: 10/02/11

NCR: 48386-1		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-01-07	140	1 arm cracked on + Le lower RH portion. RC: process.	<u>NA</u> OSM2	2:ip cut out the affected area. clean & re-weld per QSI cond.	<u>1/2</u> 10-01-08	<u>S</u> 10/01/11	<u>OSM2</u>	<u>10-01-07</u>

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 9:24:26 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 48386

Part Number: D3560042

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 ✓ HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 10-01-12 (7)

11.0 ✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JS 10-01-12 (7)

12.0 ✓ D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Spacer

D 46738

ES 10/01/12

13.0 ✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

ES 10/01/12 (7)

14.0 ✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 10/01/13 (7)

15.0 ✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WP*

SAD 10-01-14 (7)

16.0 ✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 48384
Description: Arm		Part Number: D3560-2
Inspection Dwg: D3560	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

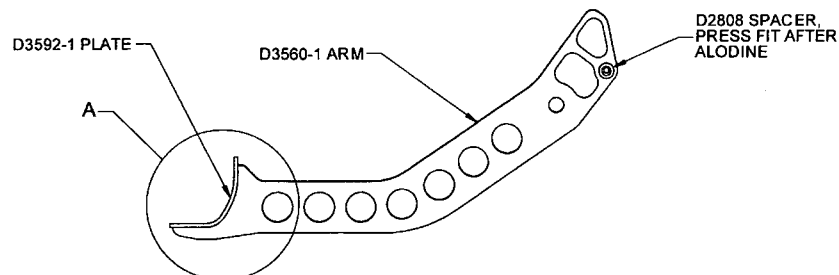
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.506	✓			
Ø0.196	+0.005/-0.001	.197	✓			
Ø1.000	+0.010/-0.001	1.003	✓			
0.500	+/-0.010	.496	✓			
0.250	+/-0.010	.251	✓			
0.275	+/-0.010	.276	✓			
0.188	+/-0.010	.182	✓			
2.000	+/-0.010	2.000	✓			
1.700	+/-0.010	1.700	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.380 x 45°	✓			
0.250 Deep	+/-0.010	.253	✓			

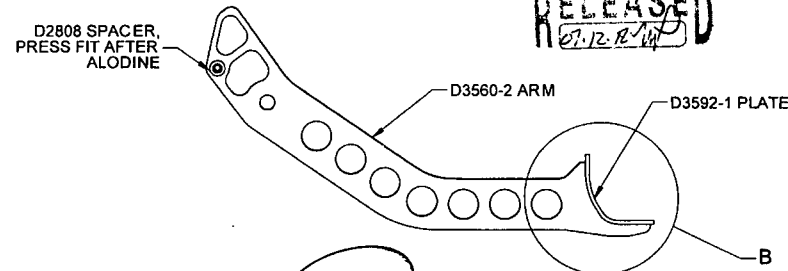
Measured by: SL	Audited by: S	Prototype Approval: N/A
Date: 09/07/08	Date: 09/02/09	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	BE

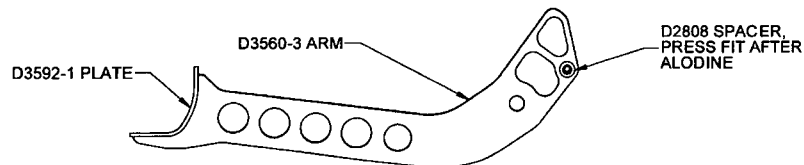
RELEASED
01.12.2014



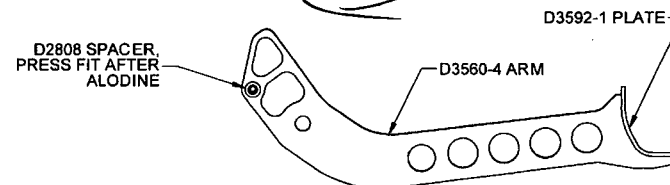
D3560-041 ARM WELDMENT



D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT

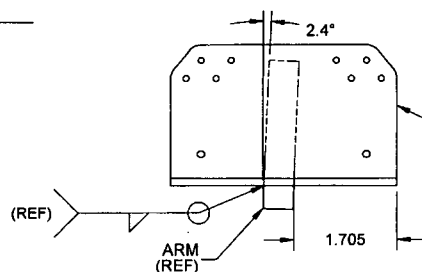
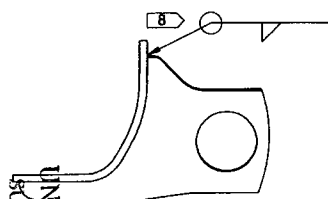
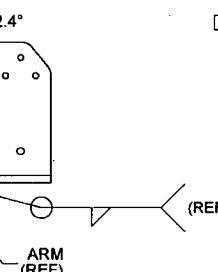
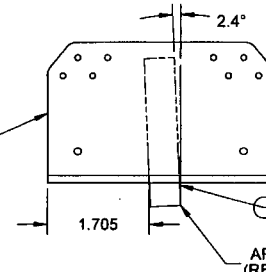


PLATE
(REF)



DETAIL B
SCALE 1:2

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

DESIGN	D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	C	REMOVE POWDER COAT	CP	07.06.19
CHECKED	B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
MFG. APPR.	A	NEW ISSUE	CP	06.09.25
APPROVED	REV.	DESCRIPTION	BY	DATE
DE APPR.				
DATE	07.11.16			

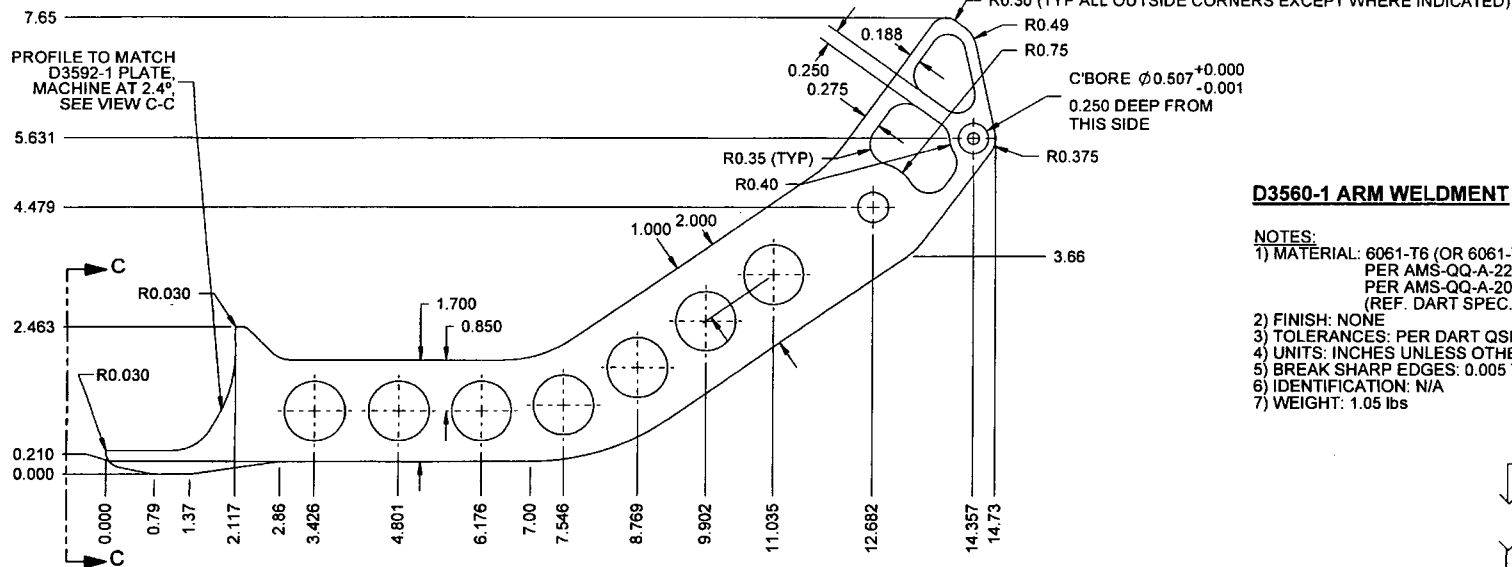
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3560
REV. D
SHEET 1 OF 5
TITLE
ARM WELDMENT
SCALE
1:4

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

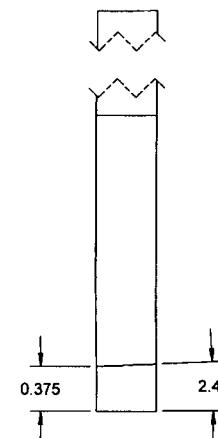
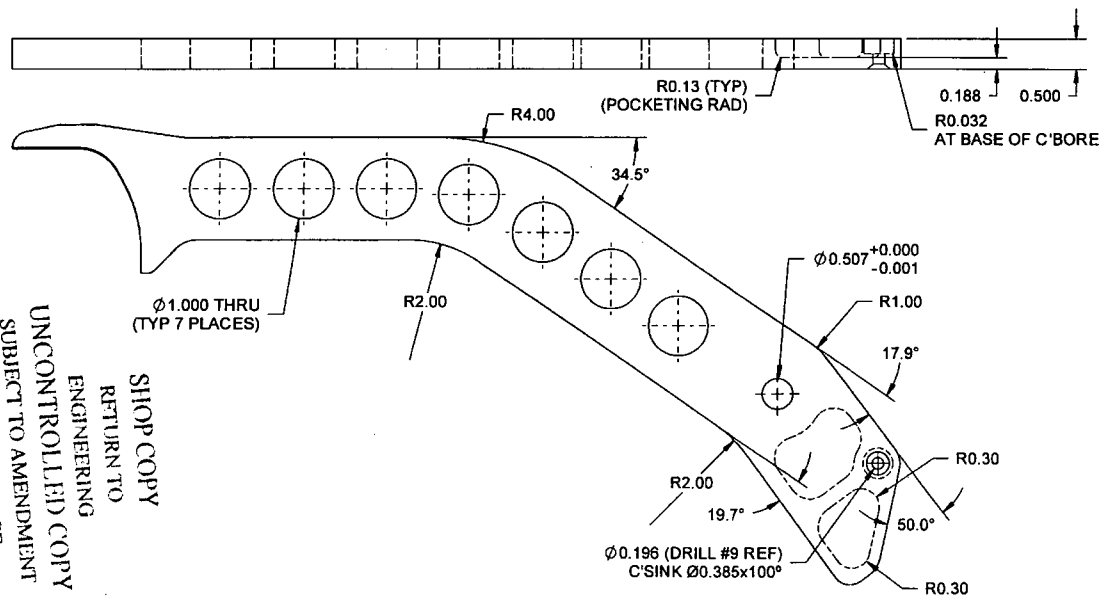
WORK ORDER
NOTES
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



D3560-1 ARM WELDMENT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



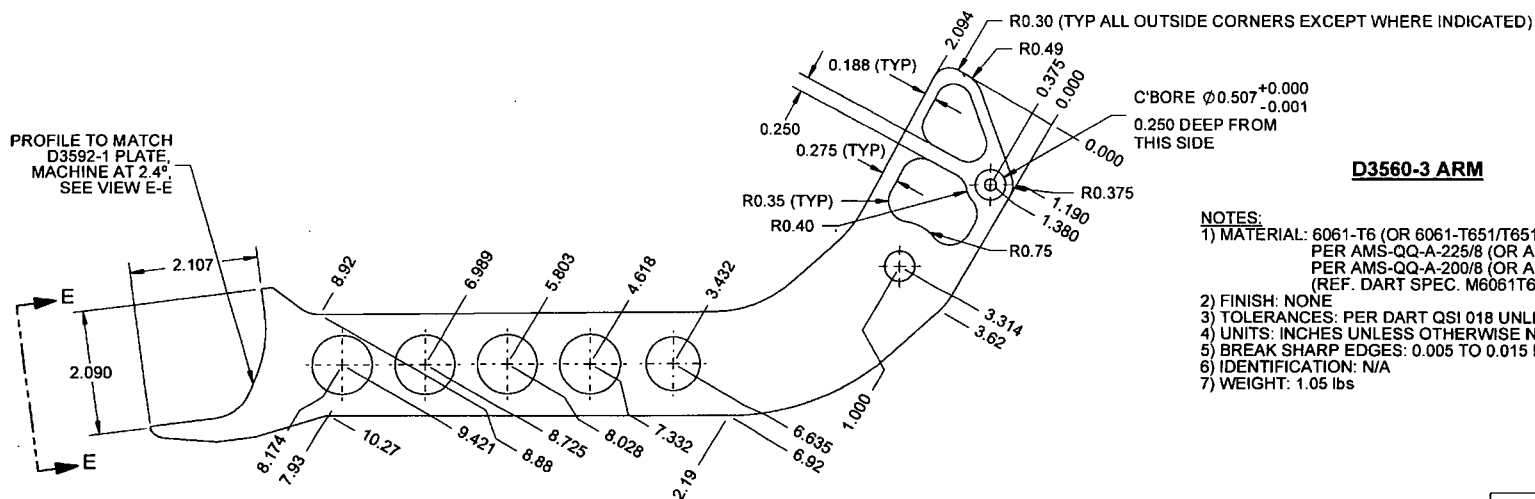
VIEW C-C
SCALE 1:1

RELEASED
07.12.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 48384

DESIGN	<i>g</i>	DART AEROSPACE LTD	
DRAWN	<i>jc</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>g</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>g</i>	D3560	SHEET 2 OF 5
APPROVED	<i>My</i>	TITLE	SCALE
DE APPR.	<i>g</i>	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THAT IT IS	

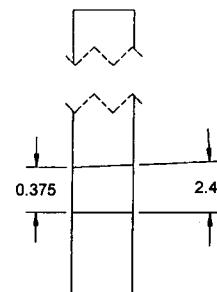
PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4°
SEE VIEW E-E



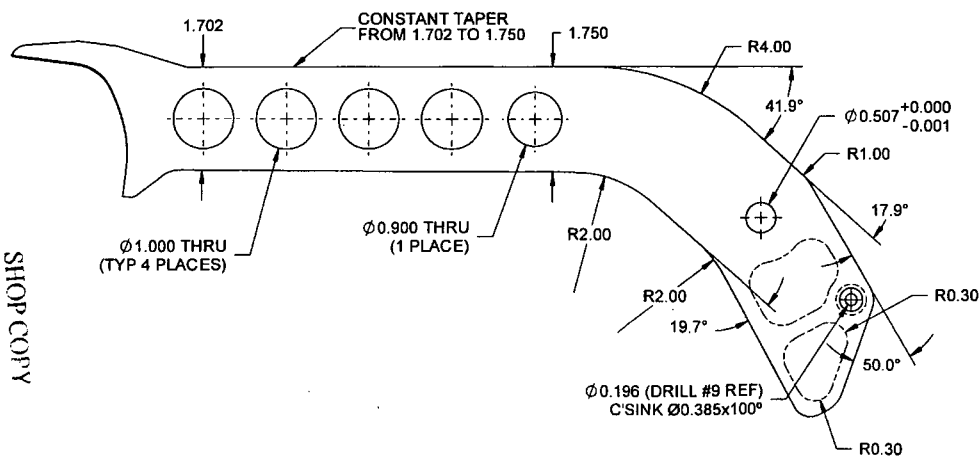
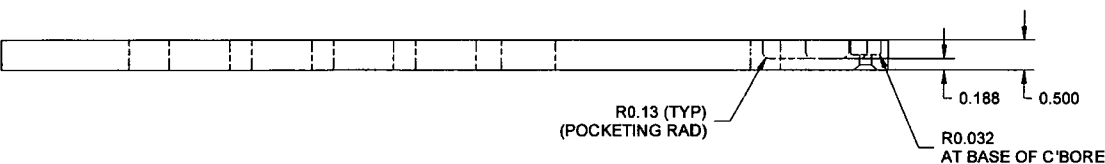
D3560-3 ARM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW E-E
SCALE 1:1

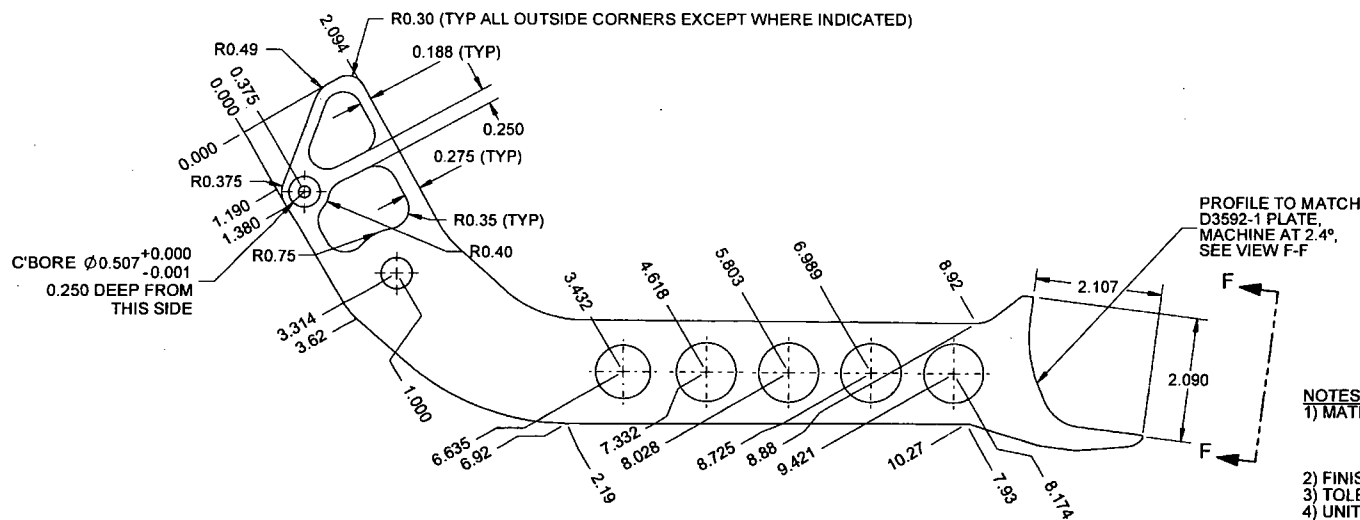


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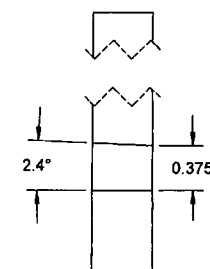
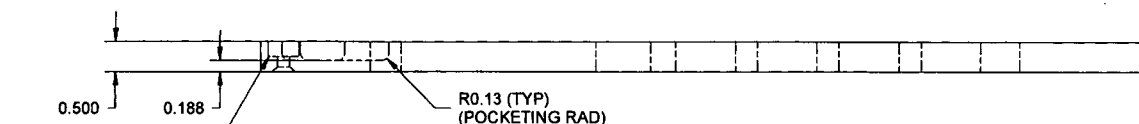
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DRAWN	JC		
CHECKED	JP	DRAWING NO. D3560	REV. D
MFG. APPR.	JP	SHEET 4 OF 5	
APPROVED	JP	TITLE ARM WELDMENT	SCALE 1:2
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DATE	07.11.16		



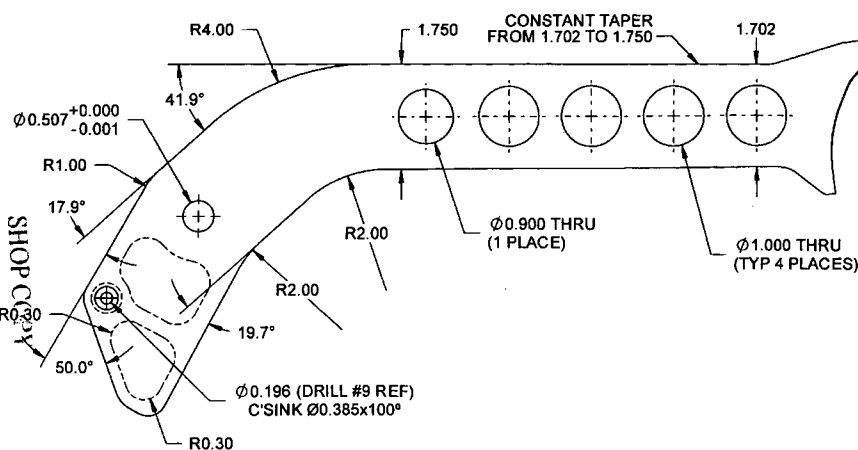
D3560-4 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

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MFG. APPR.	PC	D3560	SHEET 5 OF 5
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DE APPR.	PC	ARM WELDMENT	1:2
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